

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HOUSING WELDMENT		
Job Number	: 37604 <i>✓</i>			Part Number	: D2207041		
Estimate Number	: 11874			Drawing Number	: D2207 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 2/26/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 3/22/2008		
Previous Run	: 35075			Qty:	10	Um:	Each
Written By	<i>Karen 02/26</i>						
Checked & Approved By							
Comment	: Est. C 01-10-18 Added Step 10 and 11 SM Est. D 07-10-11 REV C dwg			DD	verified by EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:			
1.0	D2208	End Cap			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) End Cap Pick: Qty Part Number Description Batch 2 D2208 End cap <i>337743 ✓ 08/03/31</i>					
2.0	D22071	Housing			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Housing Pick: Qty Part Number Description Batch 1 D2207-1 Housing <i>B36094 → 8x ✓ 08/03/31</i>					
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1			
Comment: LARGE FABRICATION RESOURCE 1 1-Chamfer D2208 and D2207-1 before welding 2-Weld as per dwg D2207 3-Grind welds flush as per Dwg D2207 <i>SP 08.12.18 8x</i>					
4.0	Q2207 Q2-10/5	VISUAL WELDING INSPECTION			
Comment: VISUAL WELDING INSPECTION <i>S 08/12/18 8x</i>					

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Part Number: D2207041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



PT
09/02/25

Comment: SMALL FABRICATION RESOURCE 1
Drill holes using DT8557 as per Dwg D2207

FF 08/12/22

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/25 (B)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



x6
09/02/25

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

09/02/25

8.0 POWDER COATING POWDER COATING



M109996

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

09-02-25

9.0 QC3 INSPECT PC



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-25

10.0 ALS71032130 Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Insert

Qty Part Number

Description Batch

4 ALS7-1032-130 Insert

M108606

SEE QSI 017

D2207041
13 37604
25/02/2009
S.047 15.38
#1 323.1 F
#2 300.1 F
#3 0.0 F
#4 0.0 F



11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Install AK57-1032-130 as per Dwg D2207

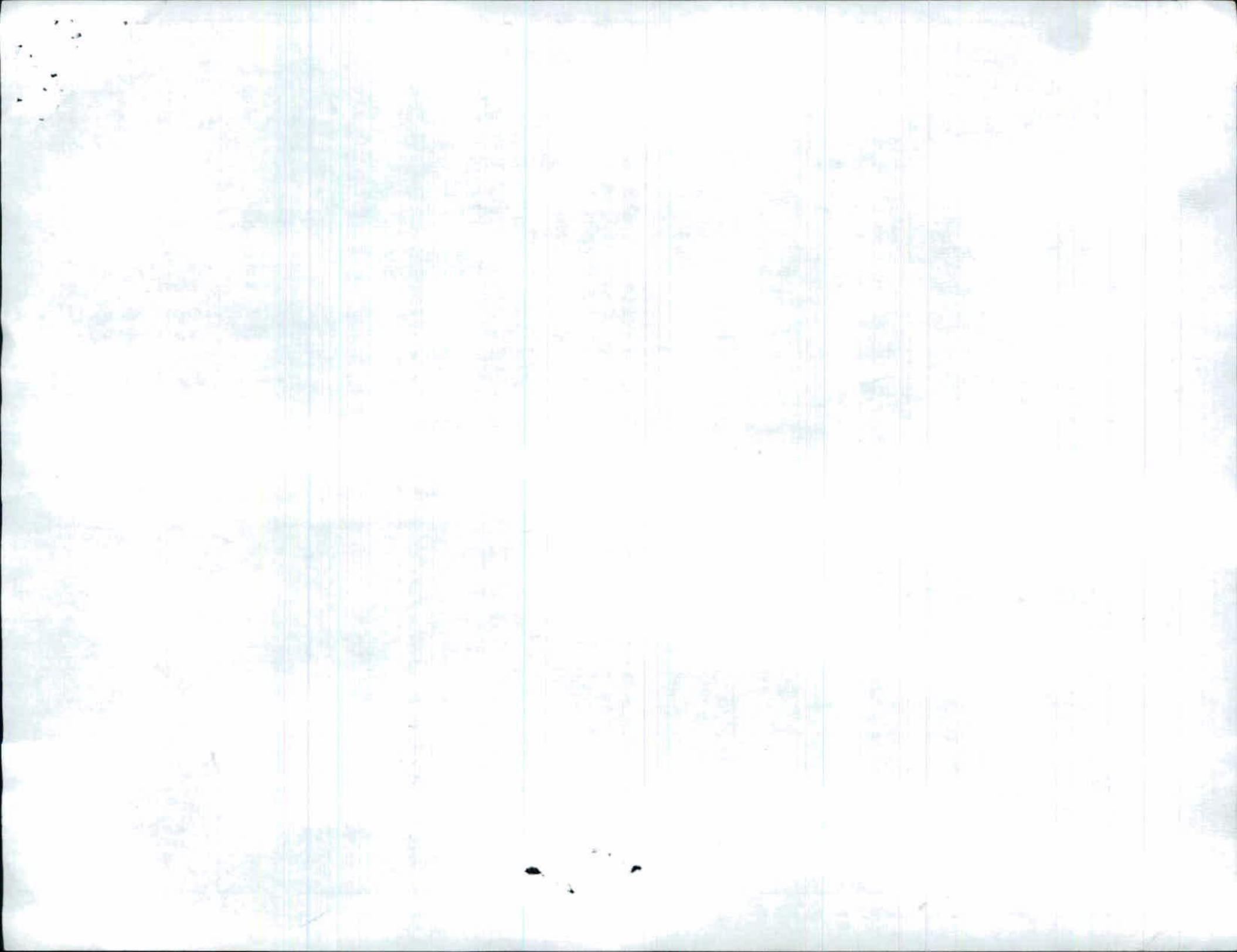
09-02-25

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/26 (x6)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2207-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/22	5.0	1 Hole out of tolerance, drill got caught and enlarged Hole R.C: Part moved/ process.	POSTUP	Scrap + Destroy Not repare Replace	FF 08/12/22	08/12/22	08/12/22	08/12/22
08/12/22	3.0	reweld holes on part grind flush Holes were not drilled to clearing. Were off 0.060" → 0.068" UP: ACROSS.	08/12/22	reweld holes on part grind flush ready for redrilling + Re-drill with DT 9460	FF 08/12/22 09/02/22	09/02/22	08/12/22	08/12/22

NOTE: Date & initial all entries

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Drawing Name: HOUSING WELDMENT

Job Number: 37604

Part Number: D2207041

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PP0 42904 x5

ST 473 x1

850902120666

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C209102126.

DART AEROSPACE LTD	Work Order:	B37604
Description: Housing Drill jig K19466	Part Number:	A2207-041
Inspection Dwg:	Rev: S	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

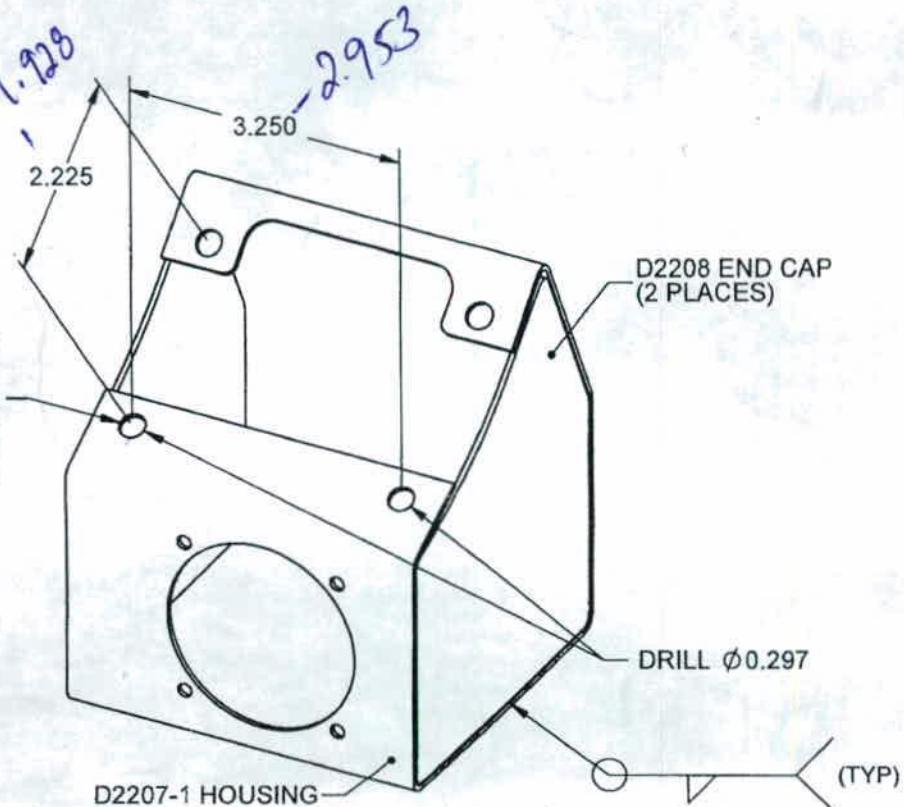
X First Article Prototype

Measured by:	<u>AB</u>	Audited by:	<u>AB</u>	Prototype Approval:	N/A
Date:	09/02/24	Date:	09/02/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

✓

AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)



RELEASED

07.08.29

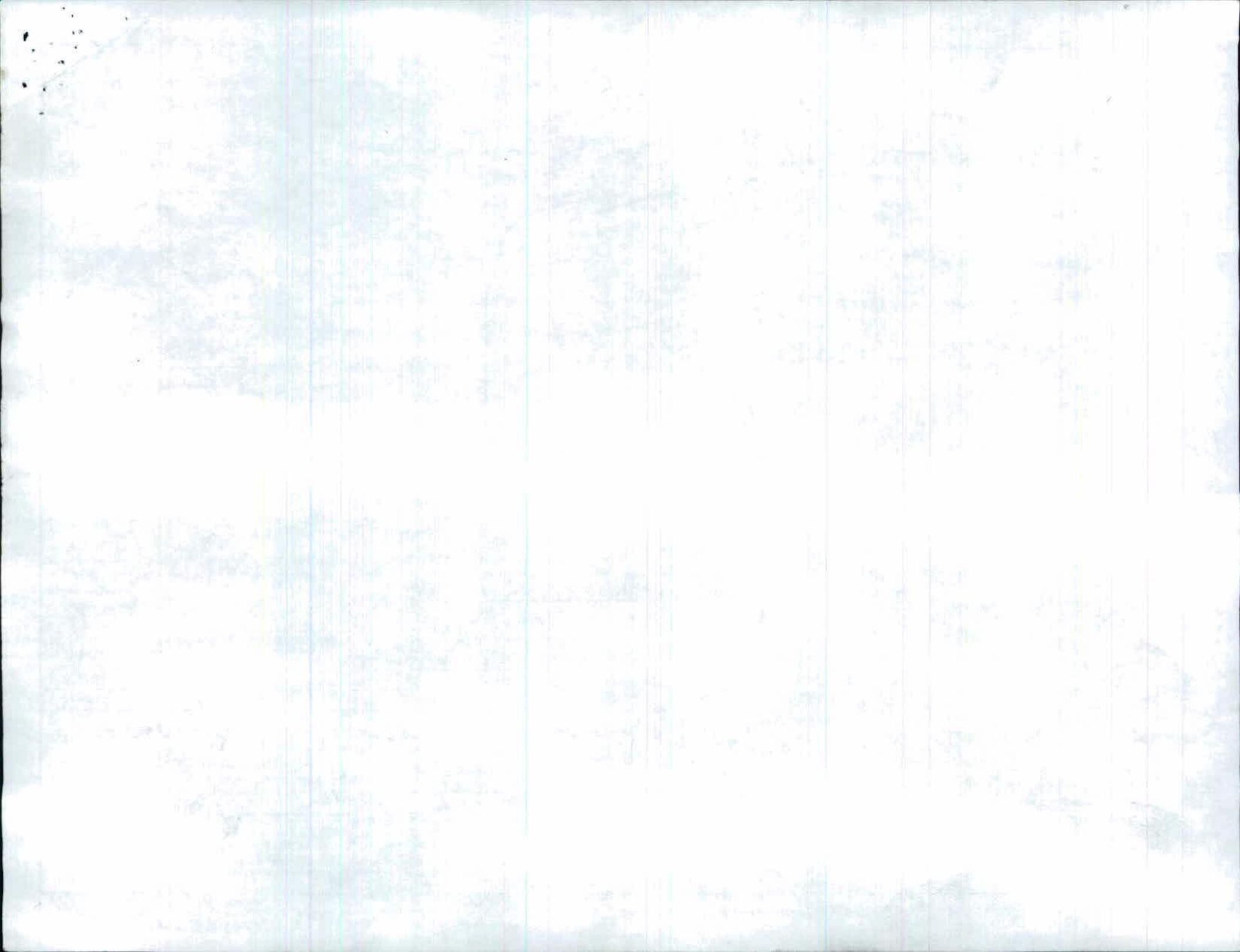
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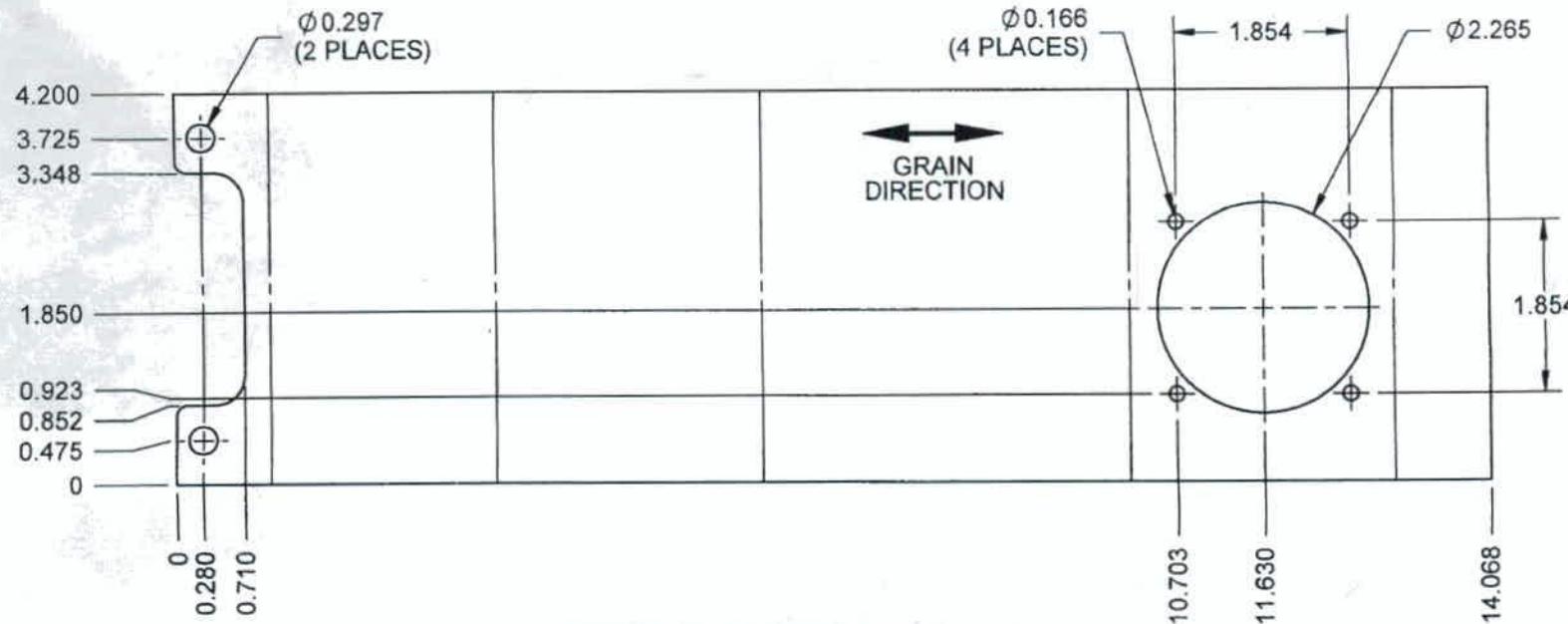
D2207-041 HOUSING ASSEMBLY

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27604
SHOP COPY
RETURN TO
ENGINEERING

NOTES:
 1) WELD PER DART QSI 004
 2) GRIND WELDS FLUSH
 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION		BY DATE
DESIGN	<i>77</i>		DART AEROSPACE LTD
DRAWN	<i>JA</i>		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>		REV. C
MFG. APPR.	<i>E</i>		SHEET 1 OF 2
APPROVED	<i>TA</i>		SCALE
DE APPR.	<i>TA</i>		1:2
DATE	07.06.28		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

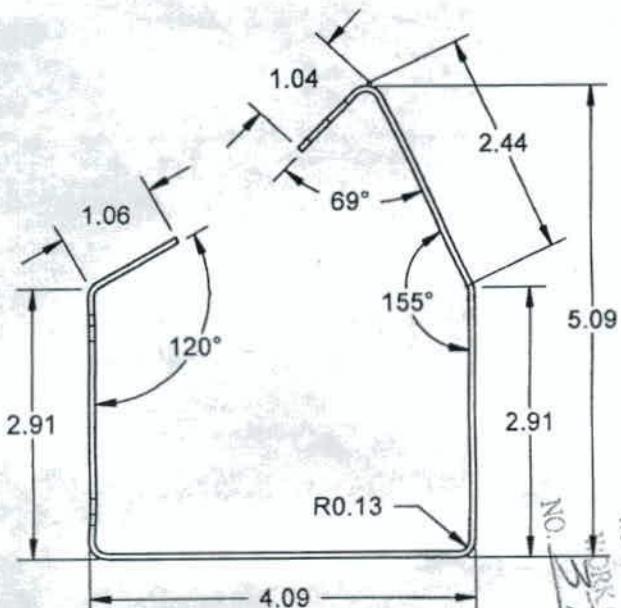




D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



D2207-1 BENDING DETAIL

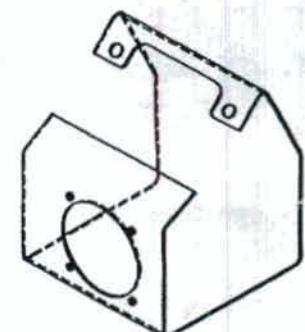
37604

NO. 1
WORK ORDER
SUBJECT TO AMENDMENT
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ENGINEERING COPY
RETURN TO
SHOP COPY

RELEASED

07.08.29

DESIGN	77	DART AEROSPACE LTD
DRAWN	JB	HAWKSLEY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	E	D2207
APPROVED	BB	REV. C
DE APPR.	BB	SHEET 2 OF 2
DATE	07.06.28	SCALE
		1:2
		HOUSING
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ISOMETRIC VIEW
(SCALE 1 : 4)